

Work Order ID 77675

77675

Page 1

December-16-11 11:09:36 AM

Item ID: D3929-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gusset Assembly
 Start Date: 16/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3929	Rev A

100		0.00							
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100 B11-12-28

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110 B11-12-29

QC Memo 0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

77675

December-16-11 11:09:36 AM

Accept

N900040100

Setup Start ***NS1***

Stop *NS2*

Cust Item ID:

6

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

0.00

QC

Memo

Quality Control

140

0.00

140

0.00

Large Fab

Memo

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 4115778

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

0.00

QC

Memo

Quality Control

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8, 17, 16, 11, 70		(72)			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ <i>Basket cell</i> Memo	0.00 0.00							<i>12-01-20</i> (72)
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/1/23</i> (72)

12-01-23 (72)

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NOTE: Date & initial all entries

Picklist Print

December-16-11 11:09:41 AM

Page 1

Work Order ID: 77675

77675

Parent Item: D3929-041

D3929-041

Parent Item Name: Gusset Assembly

Start Date: 16/12/2011

Required Date: 22/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

61.9000

0.45

2.842105

3.5

M304S11GA

**

B11-52-08

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

61.9

119006

32.5

119048

29.4

119049

D3907-1

Manufactured

No

130

Each

37.0000

2

12

D3907-1

**

12.01.20

Bushing

Location

Loc Qty

Loc Code

WA005

37

65920

4

70673

1

73008

32

14x

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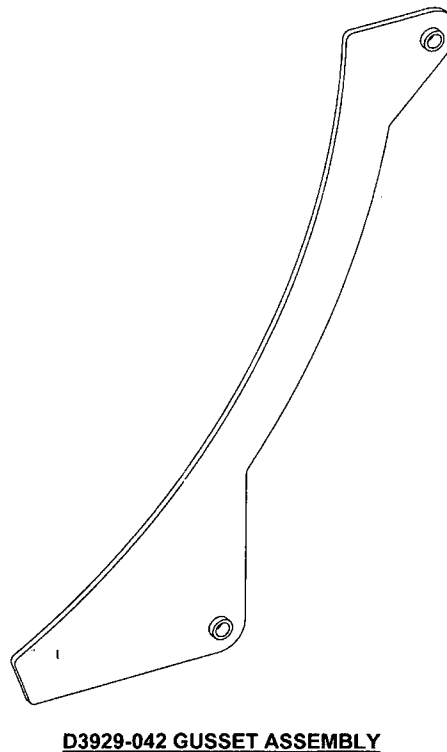
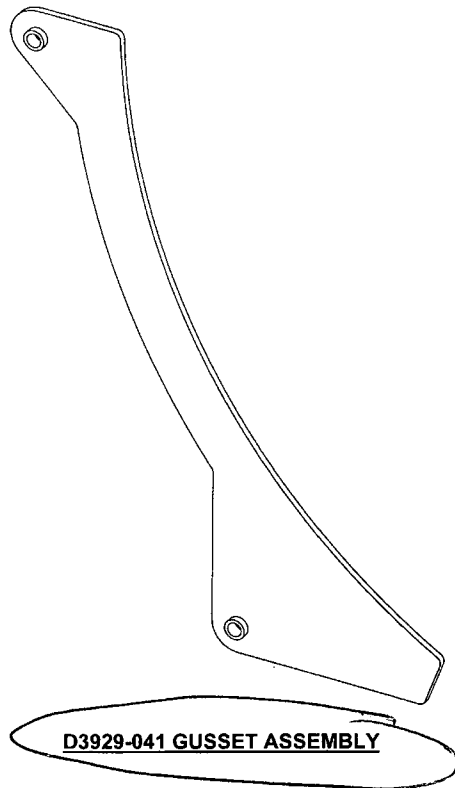
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 77635 M.C. J
11/12/16



RELEASED
07/04/22 M

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.73 lbs EACH
 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 DRAWING NO. **D3929**
 TITLE **GUSSET ASSEMBLY**
 SCALE NTS
 REV. A SHEET 1 OF 3
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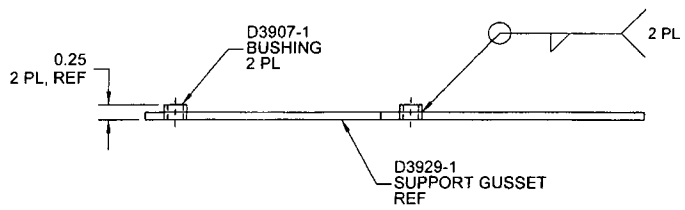
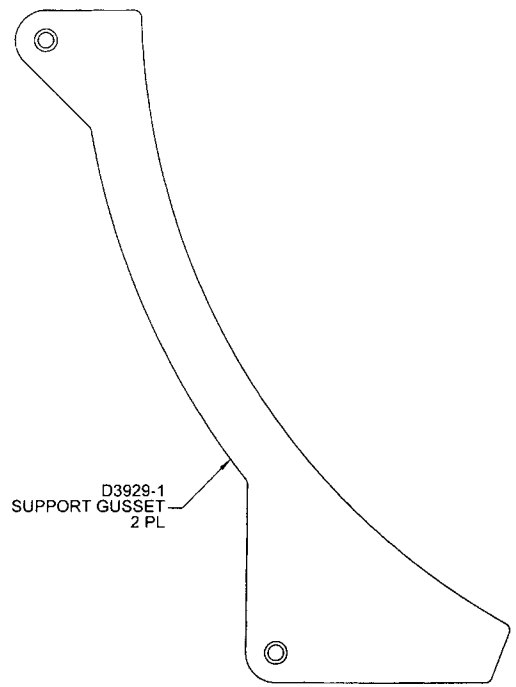
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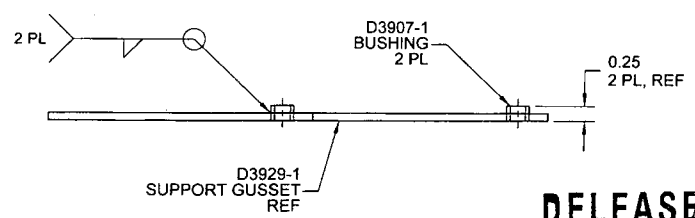
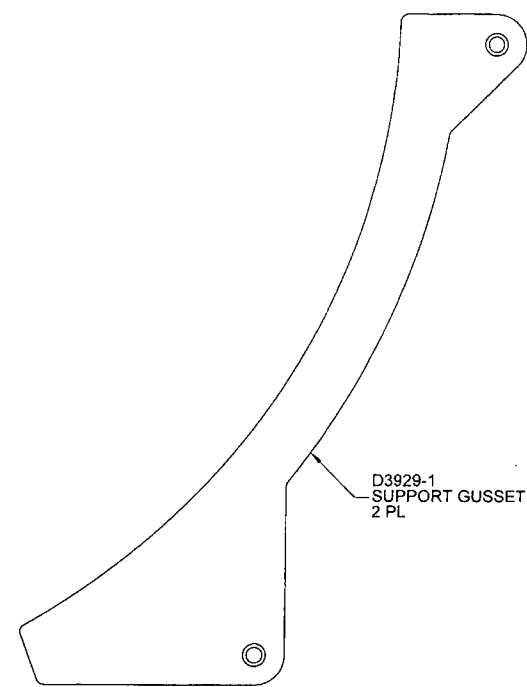
C

B

A



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		GUSSET ASSEMBLY	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

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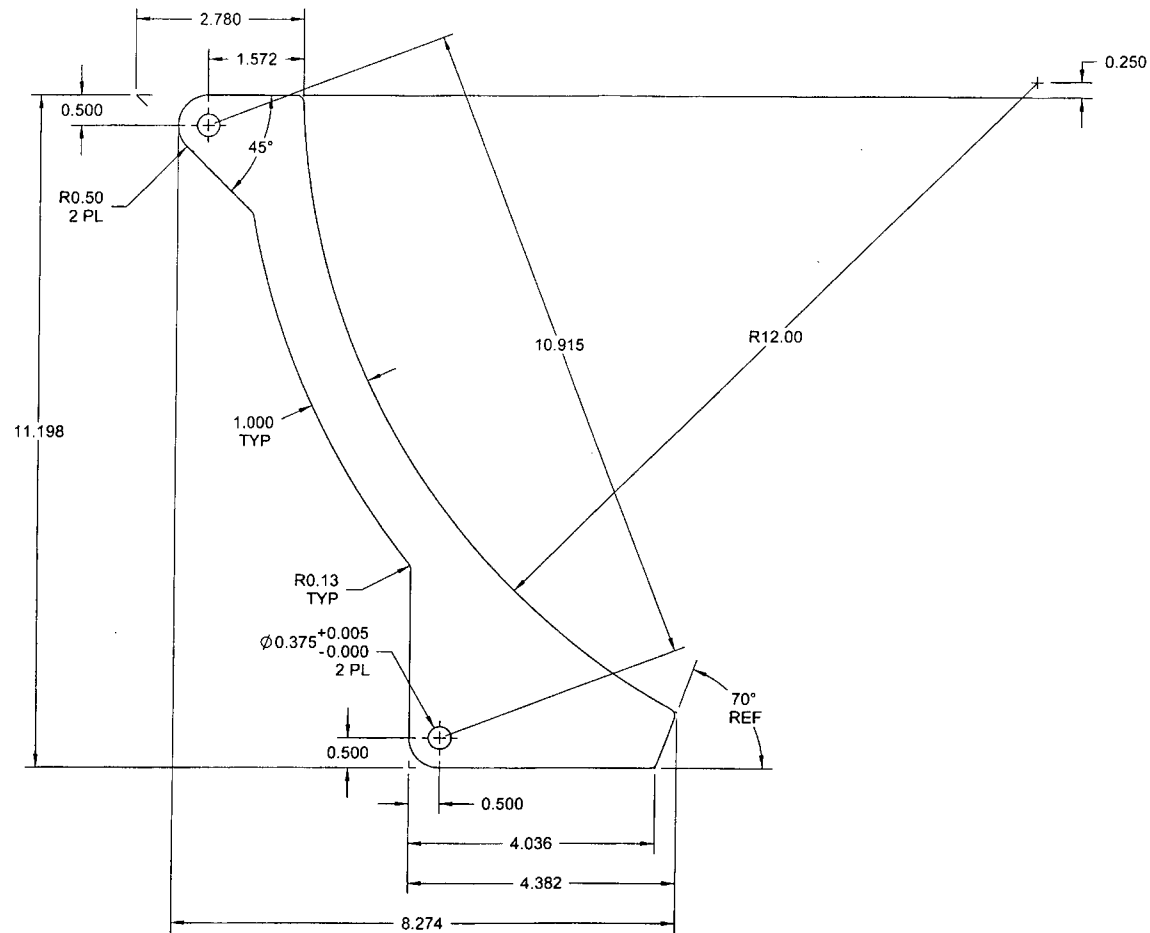
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D3929-1 SUPPORT GUSSET

RELEASED
9/04/22

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
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